

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009817**Date Inspected:** 22-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang chung ging, Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower/OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY #10

This QA Inspector randomly observed the following work in progress.

NORTH TOWER LIFT # 3

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040343 performing Flux Core Arc Welding process for the weld joint NSTL3-3B/K -84B located on PCMK corner seam between skin A and skin E of north tower lift 3. ZPMC QC Mr. Jiang Bo monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F) Repair.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 052493 performing Shielded Metal Arc Welding process for the weld joint NSTL3-3B/K -84A located on PCMK corner seam between skin A and skin E of north tower lift 3. ZPMC QC Mr. Jiang Bo monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F) Repair.

NORTH TOWER LIFT #4

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040256 performing tack welding with Shielded Metal Arc Welding process for the weld joint between bottom double diaphragms at 123m to skin C of north tower lift #4. ZPMC QC Mr. Zou Jian monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4314-TC-P5-F.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 1AAW- 1AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 048659 performing Shielded Metal Arc Welding process for the weld joint OBW1A-004 (in-side) on the excavated areas located on PCMK side panel splice weld between of OBG segment 1AAW and 1AW cross beam side. The Y location measured approximately 2240mm and 3500mm from cross beam side. ZPMC QC (CWI) Mr. Xu Yumin monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F) Repair-1. The weld repair report identified as B-WR8286.

OBSERVATION

OBG SEGMENT 2AE- 2BE

This Quality Assurance (QA) Inspector observed ZPMC personnel gouged the bottom panel splice weld (inside) between OBG segment 2AE and 2BE at three different locations as detail below.

‘Y’ LOCATION

LENGTH OF EXCAVATION

- | | |
|-------------------------------------|-----------------------|
| 1) Approximately 1070 mm to 1200 mm | approximately 130 mm |
| 2) Approximately 1500 mm to 5000 mm | approximately 3500 mm |
| 3) Approximately 5600 mm to 8250 mm | approximately 2650 mm |

‘Y’ locations are measured from cross beam side longitudinal diaphragm.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Dawson,Paul

QA Reviewer